

**Work Order ID 72113**

Tuesday, July 19, 2011 11:17:57 AM

Page 1

Item ID: D139-799-013

Accept

Setup Start

Revision ID:

Stop

Item Name: Cargo Door Hinge

Start Date: 7/19/2011 Start Qty: 2.00

Cust Item ID:

Required Date: 7/25/2011 Req'd Qty: 2.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 11-07-19

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

IIN-D139-799

D

0.00

100



DC

Document Control

Memo

Photocopy bluefile & type labels per PPP D139-799-013  
CHG002

0.00

S u l o l o s

J L O R M L S 11-9-30

110



Packaging

Packaging

Pick Kit

Memo

0.00

0.00

11/9/30 S (20)

120



QC

Quality Control

QC4- 100% Inspect kits for completeness

Memo

0.00

0.00

S u l o l o s

(42)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 72113**

Tuesday, July 19, 2011 11:17:57 AM

Page 2

Item ID: D139-799-013

Accept

Revision ID:

Item Name: Cargo Door Hinge

Start Date: 7/19/2011 Start Qty: 2.00

Required Date: 7/25/2011 Req'd Qty: 2.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00



Packaging

Memo

0.00

Identify and pack for shipping as per PPP D139-799-013

Location: 50PPP rev: A

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/10/11 629 2011/10/11 dfmf 11-10-09

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**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, July 19, 2011 11:18:04 AM

Page 1

Work Order ID: 72113

Parent Item: D139-799-013

Parent Item Name: Cargo Door Hinge



Start Date: 7/19/2011

Required Date: 7/25/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 10.06.08 new issue DD verf:JLM  
AS PER ECN 11-598 11-06-05 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2585  Mounting Channel		Manufactured	No			110	Each	75.0000	1	2			
<div> <div>ST017</div> <div>69536</div> <div>70814</div> </div> <div> <div>Loc Qty</div> <div>75</div> <div>19</div> <div>56</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div>													
D2586  Door Latch		Manufactured	No			110	Each	98.0000	1	2			
<div> <div>ST204</div> <div>64774</div> <div>70557</div> </div> <div> <div>Loc Qty</div> <div>98</div> <div>48</div> <div>50</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div>													
D2621  Latch Plate, 350 Spacepod		Manufactured	No			110	Each	34.0000	1	2			
<div> <div>ST019</div> <div>56526</div> </div> <div> <div>Loc Qty</div> <div>34</div> <div>34</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
D3552-13  Door Prop		Manufactured	No			110	Each	11.0000	1	2			
<div> <div>ST272A</div> <div>56392</div> <div>69668</div> </div> <div> <div>Loc Qty</div> <div>11</div> <div>1</div> <div>10</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div>													

*B73297*

*B73296*

*B72401 11/11/35*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Tuesday, July 19, 2011 11:18:04 AM

Page 2

Work Order ID: 72113

Parent Item: D139-799-013

Parent Item Name: Cargo Door Hinge

Start Date: 7/19/2011

Required Date: 7/25/2011

Start Qty: 2.00

Required Qty: 2.00

D3622-1

Manufactured No

110 Each

36.0000

1

2



Ball Stud



B721025

Location

Loc Qty

Loc Code

ST070

36

67284

15

71540

21

D3622-3

Manufactured No

110 Each

42.0000

1



Ball Stud



D

Location

Loc Qty

Loc Code

ST070

42

52939

2

53951

40

D4072-1

Manufactured No

110 Each

0.0000

2

4



Airframe Hinge



B721045

D4072-3

Manufactured No

110 Each

24.0000

2

4



Airframe Hinge Backing Plate



B721055

Location

Loc Qty

Loc Code

ST119

24

71536

24

D4072-5

Manufactured No

110 Each

27.0000

4

8



Bushing



B72680 11/01/35 (20)

Location

Loc Qty

Loc Code

ST119

27

62804

2

71537

25

Tuesday, July 19, 2011 11:18:04 AM

Shop Packet Print

Page 2

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 72113

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Parent Item Name: Cargo Door Hinge

Start Date: 7/19/2011

Required Date: 7/25/2011

Start Qty: 2.00

Required Qty: 2.00



Door Hinge



Door Hinge Backing Plate

Manufactured No 110 Each 0.0000

2 4



B74242

Manufactured No 110 Each 22.0000

2 4



B74269 11/10/11

Location

Loc Qty

Loc Code

ST120

22

65947

2

71541

20



Bracket



Channel

Manufactured No 110 Each 0.0000

1 2



B72109

Manufactured No 110 Each 19.0000

1 2



B72403

Location

Loc Qty

Loc Code

ST120

19

62797

1

71543

18



Backing Plate



Striker Plate

Manufactured No 110 Each 0.0000

1 2



71544 11/10/11

Manufactured No 110 Each 1.0000

1 2



11/9/10

B72112

Location

Loc Qty

Loc Code

ST120

1

62799

1

Tuesday, July 19, 2011 11:18:05 AM

Shop Packet Print

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 72113

Parent Item: D139-799-013

Parent Item Name: Cargo Door Hinge

Start Date: 7/19/2011

Required Date: 7/25/2011

Start Qty: 2.00

Required Qty: 2.00

MS21042L3

Purchased

No

110

Each

1,618.000

20

40



Nut

Location

Loc Qty

Loc Code

ST300

1618

117441

786

117601

400

~~117885~~

432

MS21042L5

Purchased

No

110

Each

1,344.000

1

2



Nut

Location

Loc Qty

Loc Code

ST300

1344

116105

5

116548

155

117441

498

~~117591~~

100

117611

90

118179

496

MS27039-1-10

Purchased

No

110

Each

187.0000

8

16



Screw

Location

Loc Qty

Loc Code

ST290

150

117441

150

ST291

37

115935

37

W/O:		WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 5

Work Order ID: 72113

Parent Item: D139-799-013

Parent Item Name: Cargo Door Hinge

Start Date: 7/19/2011

Required Date: 7/25/2011

Start Qty: 2.00

Required Qty: 2.00

MS27039-1-14 Purchased

No

110

Each

140.0000

2

4



Screw

Location

Loc Qty

Loc Code

MEZZ

140

112312

100

15924

40

Each

0.0000

8

16

MS27039-1-16 Purchased

No



Screw

MS27039-1-17 Purchased

No

110

Each

122.0000

1

2



Screw

Location

Loc Qty

Loc Code

ST292

122

11540

22

117591

100

Each

3,005.000

18

36

NAS1149D0363J Purchased

No



Washer

Location

Loc Qty

Loc Code

ST298

3005

117291

30

117505

500

117601

475

118077

2000

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item: D139-799-013

Parent Item Name: Cargo Door Hinge

Start Date: 7/19/2011

Required Date: 7/25/2011

Start Qty: 2.00

Required Qty: 2.00

NAS1149D0663J

Purchased

No

110

Each

639.0000

1

2



Washer



*11/9/30*

Location

Loc Qty

Loc Code

ST298

639

115996

5

117291

134

117977

500

NAS1515H5L

Purchased

No

110

Each

56.0000

4

8



WASHER



*11/18/14 11/29/12*

Location

Loc Qty

Loc Code

FG

40

103691

40

ST277

16

111359

16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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REFERENCE ONLY

Qty -013	Part Number	Description
X	D139-799-013	CARGO DOOR HINGE KIT
1	D2585	MOUNTING CHANNEL
1	D2586	DOOR LATCH
1	D2621	LATCH PLATE
1	D3552-13	DOOR PROP
1	D3622-1	BALL STUD
1	D3622-3	BALL STUD
2	D4072-1	AIRFRAME HINGE
2	D4072-3	AIRFRAME HINGE BACKING PLATE
4	D4072-5	BUSHING
2	D4073-1	DOOR HINGE
2	D4073-3	DOOR HINGE BACKING PLATE
1	D4074-1	BRACKET
1	D4074-3	CHANNEL
1	D4074-5	BACKING PLATE
1	D4074-7	STRIKER PLATE
20	MS21042L3	NUT (or MS21042-3)
1	MS21042L5	NUT (or MS21042-5)
8	MS27039-1-10	SCREW
2	MS27039-1-14	SCREW
8	MS27039-1-16	SCREW
1	MS27039-1-17	SCREW
18	NAS1149D0363J	WASHER (or AN960JD10)
1	NAS1149D0663J	WASHER (or AN960JD616)
4	NAS1515H-5L	WASHER

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 Revision: **E**  
 Date: 11.08.24